

Date: Thursday, 12/14/2006 3:39:30 PM

User: Kim Johnston

Process Sheet

Customer	: CU-DAR001, Dart Helicopters Services	Drawing Name	: 204 SKIDTUBE "I" BEAM
Job Number	: 29961	Part Number	: D2597
Estimate Number	: 10996	Drawing Number	: D2597 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/14/2006	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 1/10/2007
Previous Run	: 29675	Qty:	5
Written By	: <u>JA 06.12.15</u>	Um:	Each
Checked & Approved By	: <u>JA 06.12.15</u>		
Comment	: Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n - I" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick:

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

3 751

JT / JD 06-12-18 (5)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut D2500-3 to length: 84.25"

Use Jig DT8094 to drill pilot holes.

Open to 0.625 diameter using a uni-bit

JT / JD 06-12-18 (5)
JT / JD 06-12-18 (5)
JT / JD 06-12-18 (5)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

JE 06-12-18 (5)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

JT / JD 06-12-18 (5)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

JT 06-12-18 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 SKIDTUBE "I" BEAM

Job Number: 29961

Part Number: D2597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PG JD 06-12-18 (5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/18 (5)

Job Completion



U 06/12/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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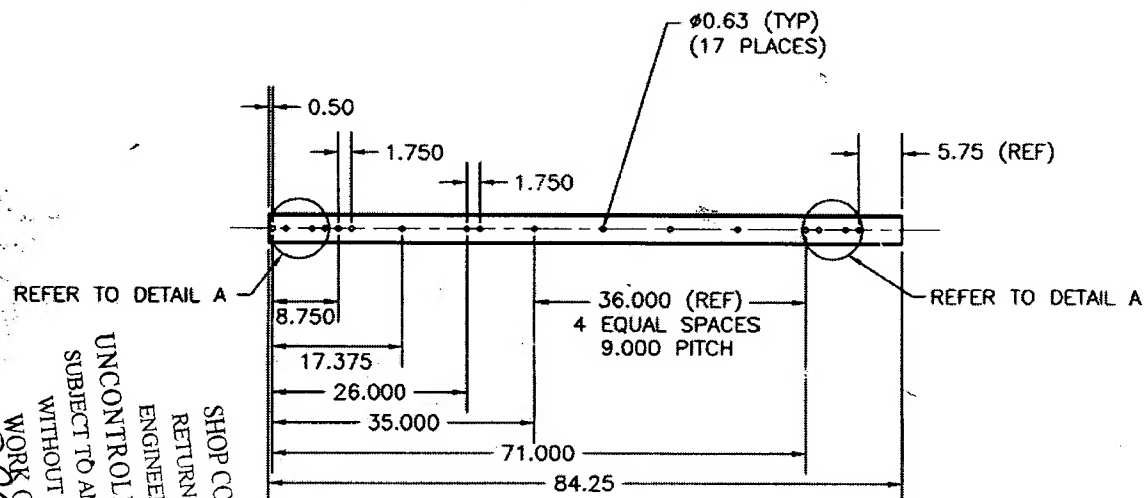
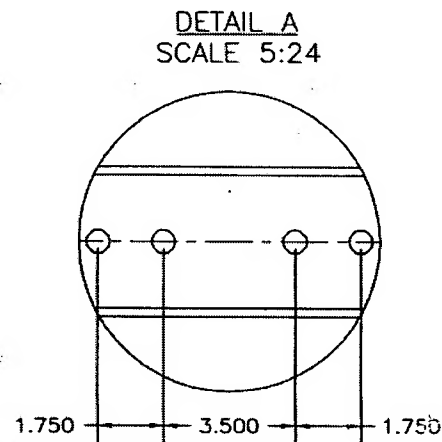
NOTE: Date & initial all entries

DART



RELEASED
48.9.11 JS

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2597	SHEET 1 OF 1
DATE	98.09.14	TITLE	204 WEB	SCALE	1:24
A	96.09.16	NEW ISSUE			
B	96.10.29	5.75 WAS 0.50			
C	97.07.23	Ø0.63 WAS Ø0.56			
D	98.09.14	INCORPORATED DEO 9097			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29961

MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

